

Work Order ID 133291

June-01-15 1:48:50 PM

133291

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Item ID: MISC - Testing

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Eng Testing

Start Date: 6/01/15 Start Qty: 1.00

Cust Item ID:

Required Date: 6/05/15 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00

100

Crosstubes

Crosstubes

Memo

- PICK D6021
- MACHINE TO 2.3" OD
- GRIND SURFACE SMOOTH USING GR80 DRUM BELT AND FINISH WITH A COARSE BLENDEX™ DRUM (WALTER SURFACE TECHNOLOGIES). CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- DEGREASE USING 4105S WASH 'N WIPE. USE CLEAN LINT FREE CLOTH. RINSE ANY RESIDUE THOROUGHLY, WIPE/DRY WITH CLEAN DRY CLOTH TO ENSURE SURFACE CONTAMINANTS REMOVED.
- KEEP ALL SURFACES CLEAN UNTIL PRIMED. USE CLEAN GLOVES TO HANDLE. SURFACES SHALL BE KEPT FREE FROM DIRT, DUST, FINGER MARKS, AND OTHER CONTAMINANTS.

3.0. 15/06/08

15-06-10

Qty (3)

6" long pieces

15/6/4

DAS

41

9-89

15-6-18

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Item ID: MISC - Testing Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eng Testing
 Start Date: 6/01/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/05/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105		0.00				3			DAS 41 9-89
105									
Crosstubes	Memo	0.00							15-6-18
Crosstubes	6. APPLY AXALTA 13205S ALUMINUM CLEANER PER MANUFACTURER'S INSTRUCTIONS 132520								
	7. APPLY AXALTA METALOK 230S ADHESION PROMOTER PER MANUFACTURER'S INSTRUCTIONS 132474								
	8. PRIME AND PAINT OUTSIDE OF TUBE PER DART QSI 005 4.2								
	9. CUT INTO (3) 6" LONG SECTIONS Prime 131846 Paint 132422								
110		0.00				3			DAS 12 9-89
110									
Eng	Memo	0.00							15/6/19
Engineering	ENGINEERING APPROVAL								

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Item ID: MISC - Testing Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Eng Testing
 Start Date: 6/01/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/05/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							DAS 12 9-89
120						3			15/6/22
Purchasing	Memo	0.00							
Purchasing	SEND TO EXOVA FOR GRAVEL TESTING PO 20902								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

ADIS-74801

20150917

Linda Lacelle

From: Chris Provencal
Sent: June-01-15 1:26 PM
To: Linda Lacelle
Cc: William Monterroza; Nigel Forbes
Subject: Need Gravel Test Samples

Linda,

Can we have 4 w/o's to create the following. This is for gravel testing at Exova:

W/O #1, Existing process (control)

Cut qty(3) 6" long sections from painted 350 tube. This tube is already painted, so it just needs to be picked. We'll pick the fill in the p/n & b/n of the picked tube.

W/O #2, Stainless w/ Metalok

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Axalta 13205S Aluminum Cleaner per manufacturer's instructions
7. Apply Axalta Metalok 230S Adhesion Promoter per manufacturer's instructions
8. Prime and paint outside of tube per Dart QSI 005 4.2
9. Cut into (3) 6" long sections

W/O #3, Stainless w/ Military wash primer

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.

5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Sherwin Williams DOD-P-15328D per manufacturer's instructions.
7. Prime and paint outside of tube per Dart QSI 005 4.2
8. Cut into (3) 6" long sections

W/O #4, Stainless w/ powder coat

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Powder coat white (4.3.5.2) per Dart QSI 005 4.3
7. Cut into (3) 6" long sections

The D6021 material should be able to be cut from the excess mat'l on the ends of the raw extrusion. I believe there's at least 12" extra material on each tube.

Thanks,
Chris